



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3492-1

Job Sheet 179054



Part No: D3492-1

Job Qty: 80 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/13/18

Job Tracking No:

Due Date: 7/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea	7/2/18	7/2/18	0.00	0.00	Start Up Machining-2	1/18	JBD
100	Hardinge	80 pcs	7/2/18	7/2/18	0.00	2.45	Hardinge	1/18	JBD
120	QC	80 pcs	7/2/18	7/2/18	0.00	0.00	QC8		18-07-12
150	HandFinish	80 pcs	7/2/18	7/2/18	0.00	0.26	HandFinish1		18-07-17
155	Outsource	80 pcs	7/2/18	7/2/18	0.00	0.00	Outsource11		
160	Powdercoat	80 pcs	7/2/18	7/2/18	0.00	0.13	Powdercoat1	BL/	18-07-19
165	Packaging	80 pcs	7/2/18	7/2/18	0.00	0.00			DAS
170	QC	80 pcs	7/2/18	7/2/18	0.00	0.00	QC3		38
180	Packaging	80 pcs	7/2/18	7/2/18	0.00	0.00	Packaging3-1	FP-001	18-07-20
190	QC21-SA	80 Ea	7/2/18	7/2/18	0.00	0.00	QC21		21 JUL 20 2018

Part Op 100 - 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev:

Descriptions: 160 - (Flat End Only) START TIME: 8:35 FINISH TIME: 9:05 TEMP: 320° 1158839

180 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	4.2400 ft (.053 ea)	90-Start up Operation	5061730

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625	4	42	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches ± 0.005	0.065 0.055		
2	Plug	0.060inches ± 0.005	0.065 0.055		
3	Plug	0.394inches ± 0.010	0.404 0.384		
4	Plug	0.625inches ± 0.010	0.635 0.615		
5	Plug	0.090inches	0.090		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
OTHER : _____									

			+ 0.000	0.088
			- 0.002	
6	Plug	0.500inches ± 0.010		0.510 0.490
7	Plug	0.050inches ± 0.002	+ 0.000 - 0.002	0.050 0.048
8	Plug	0.050inches ± 0.010		0.060 0.040
9	Plug	20.000Degrees ± 0.000		20.000 20.000

Plex 6/13/18 11:52 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Date : _____ Description Wc 		DART AEROSPACE Part: D3492-1 Job No: 179054 Serial No/Batch: S090814 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/11/18 Container No: S090814 Part: D3492-1 Job No: 179054 Serial No/Batch: S090814 DART AEROSPACE 1270 Aberdeen Street Haverhill, MA 01830 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com			
		MRB (QSI042) Approval _____			
		Completed By _____			
		Lead hand / Supervisor Approval Verification _____			
		QC / QA Coordinator Approval _____			
Root Cause					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					